

Patent Claims

1. A method of rolling and then coiling metal strip (1), especially steel strip (1) on at least one drivable spreadable coiling mandrel or core (20), whereby the metal strip (1) is inspected in longitudinal segments for rolling anomalies, characterized in that the strip samples (1a) within the rolling line (2a) are guided "in line" over a coiling station (18) located below the strip samples onto an inspection table (11) for a free viewing or perusal and stopped thereon.

2. The method according to one of claims 1 or 2 [sic], characterized in that after cutting the strip sample (1a) from the oncoming continuous rolled strip, the new strip leading end is deflected downwardly below the inspection table (11) and wound on an upper coiling mandrel (20) or a lower coiling mandrel (21) [of the coiling station (18)] lying below the inspection table (1).

3. The method according to claim 2, characterized in that the strip samples (1a) are braked on the inspection table (11) by a belt conveyor (17) integrated in the inspection table (11).

4. The method according to one of claims 1 to 3, characterized that a wound coil (25) wound upon the upper coiling mandrel (20) is swung through 180° during the continuous rolling operation and is finish wound to a predetermined maximum coil diameter (25a).

5. The method according to one of claims 1 to 4 characterized in that a wound coil 25 wound upon the lower coiling mandrel 21 is lowered and carried off parallel to the coiling mandrel axis.

6. An apparatus for rolling and then coiling metal strip (1), especially steel strip (2), wherein downstream of a rolling line and connected to the last rolling mill stand (2) an inspection device is arranged for inspecting the metal strip (2) for rolling anomalies, characterized in that the coiling station (18) is located below the plane of an inspection table (11) running "in line" to the rolling line (2a) and upon which a strip sample (1a) can be freely perused.

7. The apparatus according to claim 6 characterized in that at the inlet (27) to the coiling station 18 a deflection unit (10) is provided for deflecting the metal strip (1) to at least one coiling mandrel (20; 21).

8. The apparatus according to one of claims 6 or 7, characterized in that the coiling station(18) is constructed of a respective upper coiling mandrel (20) and lower coiling mandrel (21) arranged eccentrically within a rotating frame (28) below the plane of the inspection table (11).

9. The apparatus according to claim 8 characterized in that the upper coil mandrel (20) and the lower coil mandrel (21) lie on a diameter through the control axis (28a) of the rotating frame (28).

10. The apparatus according to one of claims 7 or 8 characterized in that the diameter runs at an angle to the horizontal of about 15° to 25°.

11. The apparatus according to one of claims 6 to 10 characterized in that the rotating frame (28) for the coiling mandrels (20; 21) is journaled for rotation on rotatably driven support rollers (2a).

12. The apparatus according to one of claims 6 to 11 characterized in that the lower coiling mandrel (21) has juxtaposed with it a pressing roller arm (30) swingable in and out and provided with a pressing roller (31).

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